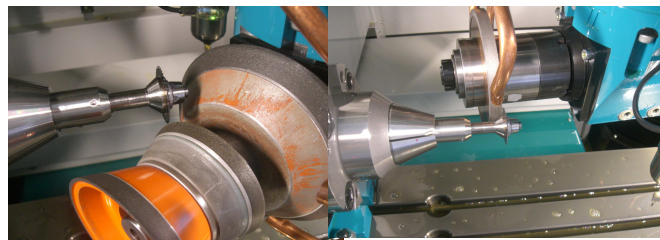















## Staggered SideMilling Cutter Ø32 Z48

### A04-015

This multitooth staggered side milling cutter is ground from a solid thin disc. The flute operation interpolates the geometrically defined bottom radius. OD and Chamfer operations are executed in optimized movements, where the main grinding movement is done Z-direction. The concave sides are ground with cylindrical grinding operations.



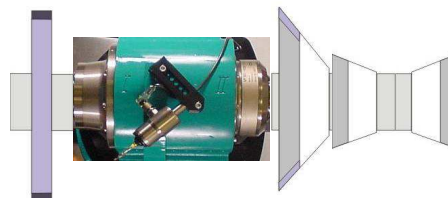
### 1. Cycletime for Production

Workpiece:	Diameter 32 mm, Z 48, Length of cutting edge 0.45 mm, Helix angle 0°						
Material HSS							
Operations							
Feed [mm/Min]	2000	200	400	400	400	3000	3000
Power [kW]		4	1	1	1	1	1
Cutting feed [m/s]		32	32	32	32	32	32
Used wheels							
Grinding time [s]	8	62	55	46	46	101	101
Total cycle time	6 Min 57						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	12V9 Ø125 B126
2	11V9 Ø75 B106
3	11V9 Ø75 B106
4	1A1 Ø125 B91



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1 3 2

### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Control: Fanuc 160i

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

Responsible engineer: OP 22.5.09

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